DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029564
Date Inspected: 06-May-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: USA Hoist

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: USA Hoist, Crest Hill, IL

CWI Name:	None present			**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ Yes	☑ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Elevator Cab frame assembly

Summary of Items Observed:

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the Fabricator's shop and observed the work and the inspection performed by USA Hoist personnel. The inspection was performed on the Elevator Cab frame assembly and on the Elevator Tower Poles. The welding was performed utilizing Flux-Cored Arc Welding with shielding gas process (FCAW-G) as per the approved Welding Procedure Specifications (WPS's).

At the start of the shift this QAI observed the following:

No Quality Control (QC) inspector was present this day.

This QAI witnessed the welding of the Elevator Cab frame assembly at the areas found deficient or lacking of welds as per the TL-6031 Daily Welding report dated 5-2-2013. The welding was performed by Manolo Luna #B as per the prequalified WPS FCAW-3139, and WPS FCAW-3133 using the gas-shielded Flux Cored Arc Welding (FCAW-G) process. The electrode utilized was E71T-1 Kobe Familiarc .045 diameter flux-cored wire as per AWS A5.20 and allowed per the AWS D1.1 Structural Welding Code. The shielding gas utilized was a 75%Argon/25%CO2 mix and was delivered at a flow rate of 35 Cubic Feet per Hour (CFH) as per both WPS FCAW-3210 and WPS FCAW-3139.

This QAI observed the welding performed and completed of the sheetmetal skin strips (2 total) item #3 to outer-face back side of the composite boxed-shape member formed from bent-plate channel members #27 and #58 assembled in a toe-to-toe configuration. For these areas of welding, WPS FCAW-3139 was utilized. This QAI monitored the in-progress welding parameters, verifying adherance to the approved WPS. The welding was

observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI witnessed the welding performed and completed of stabilizer mounting plate item #62 to C4x5.4 channel #11 where the weld was initially found deficient in it's throat size. The welding of these items was per WPS FCAW-3133. The welding was observed and verified by this QAI and appeared to be in compliance with the contract documents.

All of the remaining required welding of the Elevator Cab frame assembly has been performed and completed this day. All of the welding of this assembly appears to comply with the contract documents.

A Green Tag with a Blue Dot has been issued for the item's release to AZZ Galvanizing this day. Refer to TL-6011
Component Material Inspection Report.

Summary of Conversations:

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris,Monty	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer